

Date: Tuesday, 13/05/2008 10:11:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER ASSEMBLY
 Job Number : 39186B
 Estimate Number : 10785
 P.O. Number :
 This Issue : 13/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D31513
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3151 REV C
 Previous Run : 39186B Drawing Revision : C
 Material :
 Due Date : 30/05/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est A04.12.01 New issue KJ/JLM
 Est Rev:B 08-05-12 now made on water jet / and revise seq.6
 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 26.2500 sf(s)/Unit Total : 105.0000 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: 107572 AB 8-5-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3151

Dwg Rev: C AB 8-5-14

Prog Rev: C

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr D3151-3

n/a Done at step 2.2 08/05/14

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Drawing Name: DOUBLER ASSEMBLY

Job Number: 39186B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/14 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25/52 08/05/14 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-L 08/05/14 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify part with permanent fine point marker and Stock

Location: 22

08/05/15 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16

Job Completion



MF 08-05-25



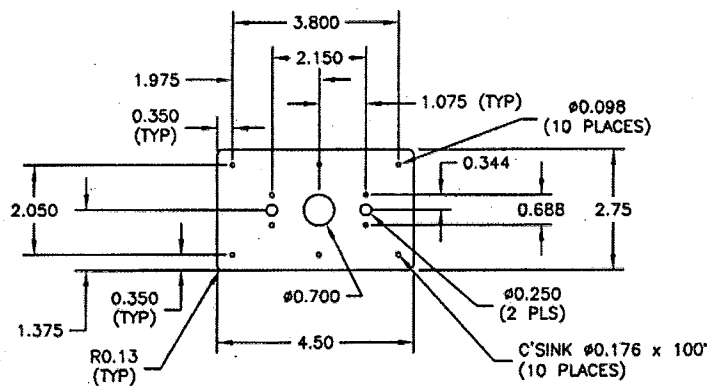
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3151	REV. C SHEET 1 OF 1
DATE 05.12.07	TITLE DOUBLER ASSEMBLY		SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	
C	05.12.07	REVISE NOTES	

MS20426AD3-3 RIVET (1)
(6 PLACES)
MS21059L08 NUTPLATE (1)
MS20426AD3-4 RIVET (2)
(2 PLACES)
D3151-3
D3151-1

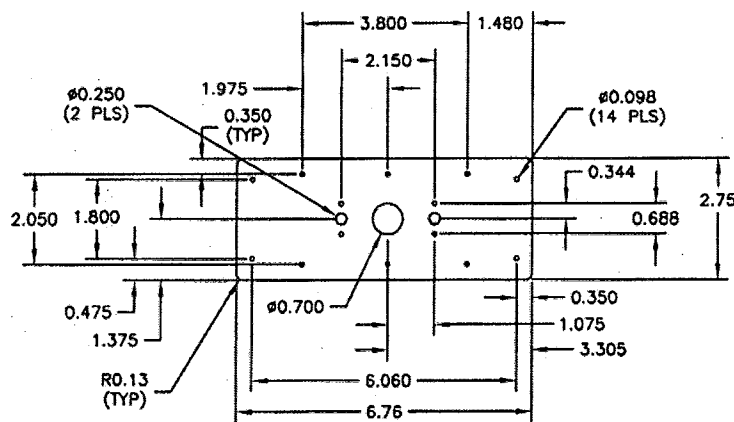
D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174

RELEASED

05.12.07



D3151-1



D3151-3

NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39186B

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DART AEROSPACE LTD		Work Order: 39186B
Description: DOUBLER ASS		Part Number: D3151-3
Inspection Dwg: D3151-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	*			
Ø .250	+ .005 - .001	.254	*			
Ø .700	+ .008 - .001	.704	*			
2.75	+/- .030	2.751	*			
6.76	+/- .030	6.763	*			
6.060	+/- .010	6.065	*			
1.075	+/- .010	1.070	*			
3.305	+/- .010	3.306	*			
.350	+/- .010	.350	*			
.688	+/- .010	.688	*			
.344	+/- .010	.344	*			
1.480	+/- .010	1.480	*			
2.150	+/- .010	2.148	*			
3.800	+/- .010	3.800	*			
1.975	+/- .010	1.975	*			
.350	+/- .010	.350	*			
.475	+/- .010	.477	*			
1.800	+/- .010	1.802	*			
2.050	+/- .010	2.047	*			
1.375	+/- .010	1.377	*			

Measured by: <u>IB</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u>N</u>
Date: <u>8-5-14</u>	Date: <u>08/05/14</u>	Date: <u>14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten Signature]